

Date: Wednesday, 5/31/2006 7:34:39 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FOLDING STEP WELDMENT RH
Job Number : 27274	
Estimate Number : 10697	
P.O. Number : <i>N/A</i>	Part Number : D3388042
This Issue : 5/31/2006 S.O. No. : <i>N/A</i>	Drawing Number : D3388 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 27270	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 6/30/2006 Qty: 5 Um: Each
Checked & Approved By : <i>[Signature] 06.05.31</i>	
Comment : Est. B 05.06.10 Added Step 11 KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
D2622-120C extrusion
Batch: *B 27077*

FF 06.07-11 5

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1
CUT D2622-120C extrusion 85.15" long as per Dwg D3388

FF 06-07-11 5

Deburr and bevel ends for welding

FF 06-07-11 5

3.0	D2734	206 Step Endplate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<i>327218=5</i> <i>324402=5</i>

L.E. 06.07.18 5

4.0	D33872	Arm
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Arm

Pick:

Qty	Part Number	Description	Batch
2	D3387-2	Arm	<i>327105=6</i> <i>327289=4</i>

L.E. 06.07.18 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #: Machine Or Operation: Description :

5.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Weld arms and (1) end cap as per Dwg D3388.
Grind end cap welds flush
Dwg Rev: A
A/R AL ROD Batch: M100660

P.E. 06.07.18
FF 06.07.20

5
5

6.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

06.07.21
(5) 06/07/21 (5)

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

SAD 06.07.25

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Weld last end cap as per Dwg D3388.
Inspect for foreign objects as per QSI 024.
Grind end cap welds flush
Dwg Rev: A
A/R AL ROD Batch: M15689
M100660

P.E. 06.07.31=5
P.E. 06.07.31=5
P.E. 06.07.31=5

9.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

06.08.01
(5) 06/08/01 (5)

10.0 HAND FINISHING1 HAND FINISHING-RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Touch up Chemical Conversion Coat as per QSI 005 4.1

a.m 06-08-04

11.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SC 06/08/08 (5)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06-07-26	7.1	QC 3 Inspect chemical conversion coat. Add step. Perm. Change	J	06-07-26	5	J	J	
06-07-31	8	inspect for foreign objects as per B51 024	KE	06-07-31	5	J	J	
		weld last end cap as per dwg D3388	KE	06-07-31	5	J	J	
		grind end cap flush	KE	06-07-31	5	J	J	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/08/28

NOTE: Date & initial all entries

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Job Number: 27274

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Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3388 and QSI 005 4.4

Q.m 06-08-08

(8)

13.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

06-08-08 (5)

14.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Spacer

Pick:

Qty Part Number Description Batch

1 D2808

Spacer

B27564

Press spacer into D3387-2 arm as per Dwg D3387

SAD 06-08-15

(7)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAB 06/08/15 (5)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

N/A

M.F. 06/08/22 (5)

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.08.24

Job Completion



W 06.08.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

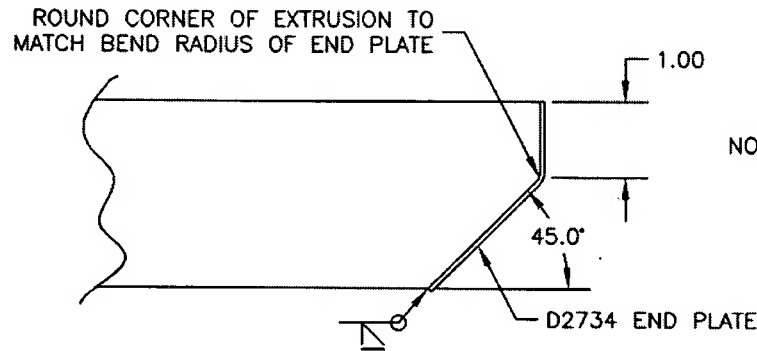
QA: N/C Closed: _____ Date: _____

DART

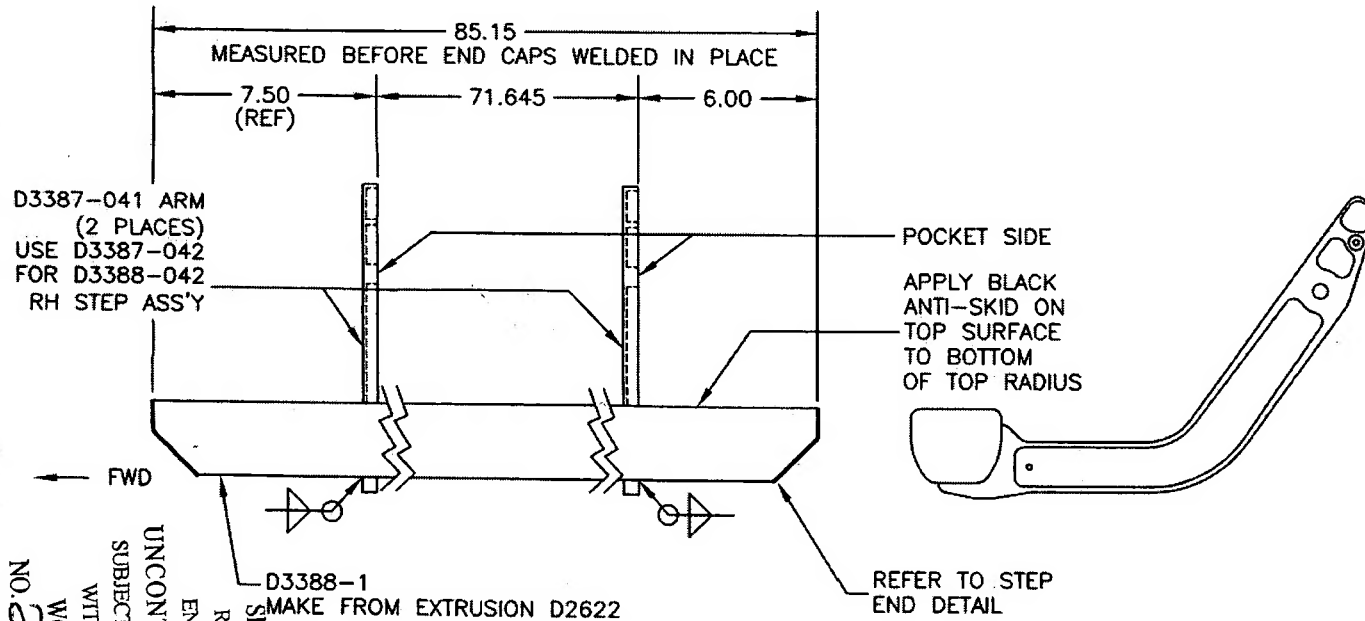
RELEASED

05-03-11

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



TYPICAL STEP END DETAIL
NOT TO SCALE



D3388-041 LH STEP ASSEMBLY (SHOWN)
D3388-042 RH STEP ASSEMBLY (OPPOSITE)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004 UNLESS OTHERWISE NOTED

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)

OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3388	REV. A
DATE 05.01.20		TITLE STEP WELDMENT	SHEET 1 OF 1
A	05.01.20	NEW ISSUE	SCALE NTS

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27274